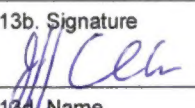


1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.		
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO 2014-42		
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work		
1.	Cargo Basket	95950-01-01	1	95911-01	New		
2.	Forward Beam, LH	95932-01-02	1	N/A			
3.	Aft Beam	95933-01-00	1	N/A			
4.	Plate	95942-01	4	N/A			
5.	Plate	95942-02	4	N/A			
6.	Bushing	95923-01	4	N/A			
7.	Bushing	95923-02	2	N/A			
12. Remarks							
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12.				
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.				
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number	
13d. Name Jeff Clarke - AD02		13e. Date (dd/mmm/yyyy) 13 May 2015		14d. Name		14e. Date (dd/mmm/yyyy)	
<p align="center">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>							

Date Opened: 17 April 2014

Job #: 959-1
Type / Project: Bell 429 Cargo Basket
Batch Quantity: 1 - RH

Approval: SH12-58, Issue 3 (Pending)
Drawing List: DCL959-15, Rev. 0 (Pending)

Drawing	Description	Task Sheet		Material List	
		Provided	Complete	Provided	Complete
95950, Rev. 0 - 84255, Rev. 1	Cargo Basket Assembly Handle Assembly	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
95951, Rev. 0	Basket Body Fabrication	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
95912, Rev. 1 - 84262, Rev. 0	Basket Lid Fabrication Lid Handle Provisions	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
94520, Rev. 1 - 84262, Rev. 1	Hoop Basket Handle Provisions	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
95964, Rev. 0	Forward Attachment Hoop	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
95926, Rev. 1	Aft Attachment Hoop	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
84261, Rev. 1	Handle Bar Assembly	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>

Work Order pre-completion Inspection:

Project is on Approval Limitation Record:

Y

Document Control List revision level matches (or exceeds) STC:

Y

Drawings revision levels match Document Control List:

Y

Purchase order or Work order source is recorded for each part/ass'y:

Y

Tests and inspections specifically called out on drawings are complete:

Y

Release tags associated with all fabricated parts are attached:

Y

List all non-conformities raised: _____


Inspector Signature:

8 Sep 14
Date:

CARGO BASKET BODY FABRICATION - COMMON

2014-42

General

429 21

These instructions apply to all cargo basket body assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only

69811, Revision 3 – Standard Low Mounted Basket

94511, Revision 0 – Extra-Wide Low Mounted Basket

94611, Revision 0 – Extra-Wide Low Mounted Ski Basket

76611, Revision 0 – High Mounted Ski Basket

Options 70404, Revision 2 – Front end cutout – 698

70411, Revision 0 – Front end cutout – 945/946

Eurocopter AS350/AS355 – left or right

77611, Revision 1 – Short Basket

76411, Revision 3 – Medium Basket (left or right)

78411, Revision 2 – Long Basket

94011, Revision 0 – Extra Large (ski) Basket

Options 70406, Revision 2 – Front end cutout – 764/776/784/940

Robinson R44 – left or right

90611, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only

80211, Revision 0 – Short Basket

80311, Revision 0 – Medium Basket

81111, Revision 0 – Long Basket

Options 70406, Revision 2 – Front end cutout – 802/803/811

Bell 429 – right or left

95911, Revision 0 – Standard Basket

→ 95951, Rev. 0

Bell Medium – left or right

75111, Revision 0 – Standard Basket

95511, Revision 0 – Extra Large (ski) Basket

Options 70407, Revision 1 – Front end cutout – 751

704, Revision – Front end cutout – 955

MD600

82811, Revision 0 – Standard Basket

Options – Applicable to all models

70403, Revision 5 – Auxiliary Latch

Work Order: 2014-42Date Open: 17 APR 2014

1. Rim Assembly – Basket Body

- a. Cut and fit $\frac{3}{4}$ " x 0.035 material to fit rim jig.
 - i. 1 or 2 lid prop bushing holes in short tube – refer to drawing
- b. Record material PO on attached material list.
- c. Remove writing on tubes with acetone and scotch bright.
- d. For extra large baskets – drill #30 (0.129) vent holes to vent stringer tubes into rims.
- e. 94611 (206L/407 XL ski) only – drill for 4 threaded bushings before assembling rim.

AD06

2. Weld Rim Assembly.

- a. Record welding rod PO on attached material list.
- b. 94611 (206L/407 XL ski) only – weld 4 threaded bushings into inboard rim tube.

AD06
AD-05

3. Inspection

- a. Rim for complete welds

AD06

4. Frame assembly – body

- a. General
 - i. Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing, hoops, etc.)
- b. Grind corner welds from step 2 on rim to allow hoops to sit flat.
- c. Pull required hoops from stock standard, attachment, handle.
 - i. If hoops are not in stock see detailed procedure sheet for specific hoop fabrication.
 - ii. Ensure vent hole is located at centre of tube to vent spine tubes.
- d. Assemble hoops with attachment lug locating jig and hoop spacing jig.
 - i. Ensure correct order and orientation of hoops. Refer to drawing.
 - 1. Attachment lugs are on inboard side.
 - 2. Handle bracket bushings are on outboard side, second hoop from both ends.
May be on attachment hoops.
 - ii. Run 3/8-24 tap into attachment lugs to ensure clear threads.
 - iii. Bolt attachment lug locating jig to attachment hoops with 3/8-24 bolts.
 - iv. Attach inboard and outboard hoop spacing jigs to all hoops using 1" C-clamps. Raise jigs approximately 2" off table to allow room to weld around hoops.
 - v. Attach bottom (spine) jig to all hoops using 1" C-clamps along the centre line of the basket. Ensure jig is straight prior to tightening all clamps.
- e. Cut $\frac{1}{2}$ " x 0.035 material to fit spine jig.
- f. Cut $\frac{1}{2}$ " x 0.035 material for strut to fit from lower inboard attachment to upper outboard rim.
 - i. Refer to applicable drawing for position, not required on some baskets.
- g. Option: Cut $\frac{1}{2}$ " x 0.035 material for front end cutout. Record material PO on attached material list.
- h. 90611 (R44) only: Cut $\frac{1}{2}$ " x 0.035 material to fit front end structure. Record material PO on attached material list.
- i. Drill vent holes into attachment hoop and/or rim to vent strut(s) and front end cutout.

AD06

- j. Record hoop WOs and material POs on attached material list.
- k. Remove writing on tubes with acetone and scotch bright.
- l. Insert rim assembly into jig and set frame assembly onto rim. Ensure correct orientation of lid prop bushings in rim to frame. Bushing hole must be closer to attachment side.
- m. Align hoops to rim in accordance with drawing. General positions:
 - i. Extra large baskets
 - 1. inboard side of hoops (attachment side) aligns to OUTSIDE of rim
 - 2. outboard side of hoops (handle side) aligns to INSIDE of rim
 - 3. forward and aft hoops align to INSIDE of rim
 - ii. All other baskets
 - 1. inboard side of hoops (attachment side) aligns to INSIDE of rim
 - 2. outboard side of hoops (handle side) aligns to INSIDE of rim
 - 3. forward and aft hoops align to INSIDE of rim, except R44

5. TIG weld frame to rim assembly.

- a. Ensure lug locating jig and hoop locating jigs are in place. Jigs must remain in place for as long as practical during welding.
- b. Strut tubes and front end cutout (see step 4.f. and g.) must be welded in place after the hoops are welded to the rim. Jig(s) must be in place prior to welding strut tubes.
- c. Robinson R44 (90611) requires fitting and welding of forward end after remainder of basket frame is welded. Use jig to support front hoop.
- d. Record welding rod PO on attached material list.

AD-05

6. Inspection

- a. Frame assembly for complete welds.

AD06

7. Mesh assembly.

- a. Pull sheet of expanded mesh from stock. Record material PO on attached material list.
- b. Cut mesh to size for body.
- c. Remove surface rust with scotch-brite.
- d. Bend body mesh – use table with bend markings on top. Lock wheels on table.
 - i. For extra wide baskets only –
 - 1. Set $\frac{3}{4}$ " angle along edge of table under mesh sheet. Set 1.5" square tube on top of mesh aligned with angle on edge of table. Clamp in place with 6" C-clamps.
 - 2. Bend upper edge of sheet just past a cell intersection to make a flange 2.5" - 3.25" wide. Closer to 2.5" is preferred, full cell intersection on flange side at bend is required.
 - 3. Bend down by hand as far as possible, then use a hammer to flatten the bend tight against the angle on the edge of the table.
 - ii. Using markings on table, align sheet to indicated edge.
 - iii. Using markings on table, align 3" tube to required position and clamp tube in place.
 - iv. Bend mesh by hand tightly over tube along length of tube.
 - v. Keeping mesh in place, un-clamp 3" tube, move to other position and clamp tube in place.
 - vi. Bend mesh by hand tightly over tube along length of tube.
- e. Install attachment lug jig onto basket frame.

AD06

- f. Ensure end struts are welded in basket frame if required by the drawing.
- g. Insert mesh into basket.
 - i. General
 - 1. Some cells may interfere with correct positioning, especially at the upper corners and around struts. Bend cell(s) in as required, do not cut cells off.
 - 2. Ideally welds will be located on mesh intersections. Shift mesh if possible to minimize welds located off mesh intersections.
 - 3. Ensure mesh reaches all edges of basket BEFORE trimming. Regardless of progress in clamping, remove clamps and shift mesh if required.
 - 4. Ensure cleco clamps are placed from the inside of the basket to allow removal during welding. Cleco clamps may be used from the outside during fitting, but must be removed prior to welding.
 - ii. Extra large baskets only – seat corner of mesh with flange into inboard upper corner of frame. Use C-clamps on edge of flange as required to maintain tight fit.
 - iii. Starting at inboard top edge of basket, clamp mesh to hoop near top rim using cleco clamps onto hoops. For regular size baskets, edge of mesh should sit approximately half way up rim tube.
 - iv. Working down the inboard side, clamp mesh to hoops with cleco clamps. Clamp down into radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, two clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
 - v. Clamp mesh to spine in at least 1 place per section.
 - vi. Working up the outboard side, clamp the mesh into the radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, 2 clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
 - vii. Trim upper outboard edge of mesh if required, edge of mesh must be low enough on rim tube to prevent the weld from protruding above the edge of the rim. Some sheets are tapered and may require ½ to 1 cell to be removed over some or all of the length of the basket. De-burr cut edges with a sanding disc on a die-grinder. Straighten cut cells with duck-bill pliers. Clamp mesh near upper edge to hoops with cleco clamps after trimming.
 - viii. Trim ends to land on hoops, at mesh intersections if possible.
- h. Cut mesh to fit ends. Record material PO on attached material list.
 - i. Remove surface rust with scotch-brite.
 - ii. Ensure mesh is cut at intersections where possible.
 - iii. Bend top edge of mesh 1/8"-3/16" down at 45 degrees
 - iv. Cut for front end cutout if required.
- i. 90611 (R44) only: Cut mesh to fit upper forward end. Record material PO on attached material list.
 - i. Remove surface rust with scotch-brite.
 - ii. Ensure mesh is cut at intersections where possible.
 - iii. Bend top edge of mesh 1/4" down at 60 degrees
 - iv. Fit mesh to front end of basket.

CARGO BASKET BODY FABRICATION - COMMON

Complete
(initial or SCA #)
AD-05

8. Weld mesh to frame assembly per drawing.
 - a. Ensure lug locating jig is in place prior to welding.
 - b. General welding requirements for all baskets, MIG welding:
 - i. Every intersection at top edges.
 - ii. Every intersection at ends.
 - iii. First 5 intersections down on hoops, then every second intersection.
 - iv. Every intersection along spine.
 - v. Extra large baskets – every intersection along corner.
 - vi. Every intersection around ends
 - vii. Every intersection along struts (if applicable)
 - c. Bend and trim cells bent in to fit mesh as required and weld in position.
 - d. Grind high spots off body mesh welds on ends before welding end mesh.
 - e. 90611 (R44) only – weld lid prop bushing (step 9) into rim BEFORE welding upper mesh on forward end of basket assembly.
 - f. Record welding rod PO on attached material list.

9. Weld basket components

- a. TIG weld lid prop bushing(s), one or two per drawing.
 - i. Record welding rod PO on attached material list.
 - ii. Record lip prop bushing WO on attached material list.
- b. TIG weld caps to close top of 1" hoops as applicable.
- c. 94611 (Bell206L/407 XL ski) only: cut rim over cross tube gap.
 - i. Cut inboard rim on aft end. Grind flush with hoops.
 - ii. TiG weld caps on open tubes.
 - iii. Record cap material PO on attached material list.
- d. 95911 (Bell 429) only: placard bracket to forward upper corner of basket.
 - i. Record welding rod PO on attached material list.
 - ii. Record placard bracket WO on attached material list.

10. Clean up

- a. Grind high spots off mesh welds.
- b. Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out. Do not tighten in corners of hoops, mesh will be deformed.
- c. Drill #9 through lid prop bushing(s). De-burr hole(s).
- d. Remove surface rust with scotch-brite pad.

11. Final Inspection

To be completed by a different person than the previous steps.

- a. Basket body assembly for complete welds, and required minimum mesh weld locations.
- b. Filled vent holes – usually on hoops
- c. Overall condition and conformity to drawing(s).
 - i. Hoops for height.
 - ii. Rim for width and length and alignment.
 - iii. Lid prop lugs in correct ends.
 - iv. Fore/aft strut in hoop if required by drawing.
- d. Material lists complete.

CARGO BASKET BODY FABRICATION - COMMON

Complete
(initial or SCA #)

- e. Tag complete basket body assembly in preparation for powder coating.

12. Powder Coating

- a. Parts are to be powder coated white in accordance with commercial practices.
- b. Record powder coating PŪ.
- c. Inspect powder coating on receiving.
- d. Tag basket body assembly and place into stock in preparation for assembly.

A001

Work Order: 2014-42Date Opened: 17 Apr 2014Material Tracking Sheet
Bell 429 - S/N 57081 Sub.
Basket Body Fabrication

1 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PC/WO
	01 <u>01</u>		95951-01- <u>01</u>	Basket Body Assembly	(-01 RH, -02 LH)	
Step 1				Rim Assembly		
	.2		--	3/4" Tube - Long Rim (9'')	4130 Steel, 3/4" x .035 Sqr. Tube	12123
	.2		--	3/4" Tube - Short Rim (25.5")	4130 Steel, 3/4" x .035 Sqr. Tube	12123
	.1		--	3/4" Tube - Long stringer (95.5")	4130 Steel, 3/4" x .035 Sqr. Tube	12123
	.4		--	3/4" Tube - Short Rim (25'')	4130 Steel, 3/4" x .035 Sqr. Tube	12111
Step 2				Weld Rim Assembly		
	A/R		--	Welding Rod	ER70S-2 TIG Rod	PO# 14033
Step 3				Inspection - Rim	None	
Step 4				Frame Assembly		
	.3		94520-01	Hoop - standard	4130 Steel, 1/2" x .035 Sqr. Tube	14009
	.1	84262	94520-01	Hoop - with handle provisions	4130 Steel, 1/2" x .035 Sqr. Tube	14009
	.1		95964-01- <u>01</u>	Forward Attachment Hoop		1
	.1		95926-01	Aft Attachment hoop - with handle provisions		12123
	.5		--	1/2" Tube - spine	4130 Steel, 1/2" x .035 Sqr. Tube	14009
	.1		--	1/2" Tube - strut	4130 Steel, 1/2" x .035 Sqr. Tube	14009
Step 5				Weld Frame Assembly		
	A/R		--	Welding Rod	ER70S-2 TIG Rod	PO# 14033
Step 6				Inspection - Frame Assembly	None	
Step 7				Mesh Assembly		
	.1		--	Mesh (Body - 56" x 96")	3/4-16F Expanded Mild Steel sheet	14012
	.1		--	Mesh (End - 24.75" x 1675")	3/4-16F Expanded Mild Steel sheet	14012

WO# 2014-04

Work Order: 2014-42Material Tracking Sheet
Bell 429 - S/N 57081 Sub.
Basket Body Fabrication

2 of 2

Date Opened: 17 APR 2014

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 8				<i>Weld Mes.</i>		
	A/R		--	Welding Rod	ER70S-6 MIG Wire	
Step 9				<i>Weld Basket Components</i>		
Step 9.a.	1		49215-01	Spacer (Lid prop)	304 Stainless Steel, 1/2" Dia.	WO# 2014-39
	A/R		--	Welding Rod	ER308L TIG Rod	PO# 14028
Step 9.b.	1		--	Cap	1018 Mild Steel, 0.032" Sheet	PO# 7016
	A/R			Welding Rod	ER70S-2 TIG Rod	PO# 14005
Step 9.c.	1		36204-10	Placard Bracket	1018 Steel, 0.035" Sheet	WO# 2014-18
	A/R		--	Welding Rod	ER70S-2 TIG Rod	
Step 10				<i>Clean Up</i>	<i>None</i>	
Step 11				<i>Inspection - Final Assembly</i>	<i>None</i>	
Step 12				Powder Coating		

CARGO BASKET HOOP FABRICATION - 84262

General

These instructions apply to all cargo basket hoops that require handle bracket provisions. Refer to the following drawings, at the current revision, for dimensions and details:

Handle Provisions – Common to all baskets
84262, Revision 1 – Handle Bracket Assembly

Work Order: 2014-42

Complete
(initial or SCA #)

Date Open: 17 APR 2014

1. Handle Bushings – Preparation – 84262-01

AD06

Required in locations where handle brackets will be installed.

- Start with stock hoop or half hoop as required for specific basket assembly.
- Setup manual milling machine with specific hoop vise jaw. Set XY 0 on far, right edge of jaw (end of hoop).
- Drill 2 places, 5/16" (0.313) holes using 5/16 (#4) centre drill through both sides in accordance with drawing. Apply a few drops of Rapid-Tap cutting oil to each location before drilling.
 - locate 0.23" from edge (within tolerance specified on drawing).
- Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
- Tag in process hoop(s) and place into stock.

2. Handle Bushings – Welding – 84262-01

AD-05

- Insert 84271-01 bushings into hoop prepared in step 2. above.
- TIG weld bushing both sides, 2 bushings per hoop.
- Record bushing and welding rod PO/WO on attached material list.
- Tag in process hoop(s) and place into stock.

3. Handle Bushings – Finish – 84262-01

AD06

- De-burr welded bushings.
- Inspect hoop for conformity to drawing.
- Tag complete and inspected hoop(s) and place into stock.

General

17 APR 2014

These instructions apply to cargo basket hoop 94520-01 and derivatives that use it as stock. Refer to the following drawings, at the current revision, for dimensions and details:

94520, Revision 0 – Hoop (Extra Wide)

Notes

1. Always bend 1 hoop start to finish to ensure stops and stock length are correct.
2. Always pull with consistent speed through the bend, do not stop during the pull, and do not over-pull once the stop is reached.

Instructions

Complete
(initial or SCA)

1. Hoop Fabrication – 94520-01

ADD

- a. Cut $\frac{1}{2}$ " x 0.035 material to 53.75", square ends.
- b. Record material PO on attached material list.
- c. De-burr cut ends using a sanding disc on a die-grinder or disc sander.
- d. Remove writing on tubes with acetone and scotch bright.
- e. On the hoop bending fixture, set the following stops:
 - i. Upper tube stop: 20.25"
 - ii. Lower bend stop: 12mm
- f. Slide stock tube through bending die up to upper stop. Rotate bending arm clockwise until tube is secure, ready to bend. Ensure tube remains tight to upper stop.
- g. Slide shim all the way forward on bender to secure tube in die
- h. Pull bending arm clockwise until stop is reached. Pull slowly with consistent pressure.
- i. Check tube bend for square using a hoop jig or carpenters square. Adjust stops if required.
- j. Repeat steps f.-i. for opposite end of tube.
- k. Check for:
 - i. hoop height: 16.75" (Outside to outside)
 - ii. hoop width just above bends: 25.25" (outside to outside)
 - iii. adjust upper stop for height if required
 - iv. adjust stock length for width if required
 - v. twist – due to pulling bending arm up or down through bend
- l. Drill #30 vent holes in bottom centre of hoop in fore/aft direction. De-burr with scotch-brite disc on die-grinder.
- m. Inspect hoops for conformity to drawing.
- n. Tag complete and inspected hoop(s) and place into stock.

Work Order: 2014-42

Material Tracking Sheet
Bell 429 - S/N 57081 Sub.
Hoops Fabrication

1 of 2

Date Opened: 17 APR 2014

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 1	<u>3</u>		94520-01	Hoop - standard	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>14009</u>
Step 1	<u>1</u>		94520-01	Hoop - with handle provisions	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>14009</u>
Step 2		84262		Welding		
	. 2		84272-01	Bushing	4130 Steel, 5/16" x 0.058 Rnd. Tube	<u>WO# 2014-26</u>
	. A/R		--	Welding Rod	ER70S-2	<u>PO# 14005</u>
Step 3				Inspection	None	
	<u>1</u>		95964-01- <u>01</u>	Hoop - attachment (forward)	(-01 RH, -02 LH)	
Step 1				Fabrication		
	. 1		--	1/2" Tube - hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>14009</u>
Step 2				Welding		
	. 1		95925-02	Lug	1018 Steel, 5/8" Rod	<u>17056</u>
	. 1		95925-03	Lug	1018 Steel, 5/8" Rod	<u>17056</u>
	. A/R		--	Welding Rod	ER70S-2	<u>PO# 14005</u>
Step 3				Inspection and Finishing	None	

Work Order: 2014-42

Material Tracking Sheet
Bell 429 - S/N 57081 Sub.
Hoops Fabrication

2 of 2

Date Opened: 17 APR 2014

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>1</u>		95926-01	Hoop - attachment (aft)		
Step 1				<i>1/2 Hoop Fabrication - 1/2" hoop</i>		
	. 1		--	1/2" Tube - hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>14005</u>
Step 2				<i>Machining</i>	<i>None</i>	
Step 3				<i>1/2 Hoop Fabrication - 1" hoop</i>		
	. 1		--	1" tube - hoop	4130 Steel, 1" x 0.065 Sqr. Tube	<u>12 not 49210-02</u>
Step 4				<i>Machining</i>	<i>None</i>	
Step 5				<i>Joint Preparation</i>	<i>None</i>	
				<i>Welding</i>		
Step 6	. 1		95926-04	Lug	1018 Mild Steel, 5/8" Dia.	<u>12056</u>
	. 1		95926-05	Lug	1018 Mild Steel, 5/8" Dia.	<u>12056</u>
Step 7	. 2	84262	84272-01	Bushing	4130 Steel, 5/16" x 0.058 Rnd. Tube	<u>Wt 2014-26</u>
Step 8	. 1		76423-04	Cap	1018 Mild Steel, 0.050" Sheet	<u>9010</u>
	. A/R		--	Welding Rod	ER70S-2	<u>PO# 14005</u>
Step 9				<i>Finishing and Inspection</i>	<i>None</i>	

CARGO BASKET LID FABRICATION - COMMON

959

2014-42

429 R14

General

These instructions apply to all cargo basket lid assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only

69812, Revision 3 – Standard Low Mounted Basket; Extra-Wide Low Mounted Basket

94612, Revision 0 – Extra-Wide Low Mounted Ski Basket

76612, Revision 0 – High Mounted Ski Basket

Eurocopter AS350/AS355 – left or right

77612, Revision 1 – Short Basket

69812, Revision 3 – Medium Basket (left and right)

78412, Revision 2 – Long Basket

94012, Revision 0 – Extra Large (ski) Basket

Robinson R44 – left or right

90612, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only

80212, Revision 0 – Short Basket

80312, Revision 0 – Medium Basket

81112, Revision 0 – Long Basket

Bell 429 – right or left

→ 95912, Revision 0 – Standard Basket

Bell Medium – left or right

75112, Revision 0 – Standard Basket

95512, Revision 0 – Extra Large (ski) Basket

MD600

82812, Revision 0 – Standard Basket

Options

→ 70405, Revision 3 – Walkway

70402, Revision 1 – Lid Door

CARGO BASKET LID FABRICATION

Complete
(initial or SCA #)

Work Order: 2014-42

Date Open: 17 APR 2014

1. Rim Assembly – Basket Lid AD06
 - a. Cut and fit $\frac{3}{4}$ " x 0.035 material to fit rim jig, 45 degree ends.
 - i. 1 or 2 lid prop bushing holes in short tube – refer to drawing
 - b. Record material PO on attached material list.
 - c. Remove writing on tubes with acetone and scotch bright.
2. Weld Rim Assembly ~~not 2014-04~~
DEN AD-05
 - a. Record welding rod PO on attached material list.
3. Inspection AD06
 - a. Rim for complete welds
4. Frame assembly – Lid AD06
 - a. General
 - i. Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing)
 - b. Insert rim from step 2 into jig.
 - c. Cut and fit $\frac{3}{4}$ " x 0.035 material, 21" long, for lid cross members.
 - d. Record material PO on attached material list.
 - e. Remove writing on tubes with acetone and scotch bright.
 - f. Drill vent holes into rim to vent cross members into rim.
 - g. Locate cross members in lid rim. Refer to drawing for spacing of cross members. Clamp cross members with C-clamps to jig.
5. Frame assembly – Lid with optional walkway modification AD06
 - a. Fit cross members to rim in accordance with step 4.
 - b. Attach walkway jig with C-clamps. Ensure correct orientation of rim, refer to drawing.
 - c. Cut $\frac{1}{2}$ " x 0.035 material for walkway stringers to fit between lid cross members. Record material PO on attached material list.
 - d. Drill vent holes into cross members at walkway stringers.
 - e. Align walkway stringers on walkway jig using cleco clamps near both ends of each stringer, and clamp stringer to jig using a C-clamp in the centre
6. Weld frame assembly. AD-05
 - a. Record welding rod PO on attached material list.
 - b. Jigs must remain in place for as long as practical during welding.
7. Inspection AD06
 - a. Frame assembly for complete welds.

CARGO BASKET LID FABRICATION

Complete
(initial or SCA #)

N/A

8. Mesh assembly.

Note: 95912 (Bell 429) does not have mesh. Skip to step 10.

- Pull sheet of expanded mesh from stock. Record material PO on attached material list.
- Cut mesh to size for lid
- Remove surface rust with scotch-brite.
- Ensure lid is prepared for mesh on the correct side.

9. Weld mesh to frame assembly per drawing.

N/A

- General welding requirements for all lids:
 - Every intersection on all edges.
 - First 5 intersections along cross members, then every second intersection.
- MIG weld both short sides.
- Clamp lid over spacer at centre of lid to pre-tension mesh
 - 3/4" for lids under 76"
 - 1" (check) for lids over 76"
- Weld remainder of mesh as indicated in a.
- Record welding rod PO on attached material list.

10. Weld lid components.

AD-05

- Handle brackets, locate in accordance with drawing.
 - Standard location: 1/4" outside of last cross member on both ends.
 - Record handle bracket WO and welding rod PO on attached material list.
- Lid prop bushing(s).
 - one or two in accordance with drawing.
 - Record lip prop bushing WO and welding rod PO on attached material list.
- Placard bracket. – not installed on 95912 (Bell 429)
 - Locate on cross member to set bracket in centre bay of lid.
 - Record placard bracket WO and welding rod PO on attached material list.

11. Clean up

2006

- Grind high spots off mesh welds.
- Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out. N/A m
- Straighten lid using frame attached under welding table. Work carefully, avoid excessive force to prevent kinking rim tubes.
- Drill #9 through lid prop bushing(s). De-burr hole(s).
- Drill for lid bumpers using 1/4" (#3) centre drill.
 - 3 places for lids under 76"
 - 4 places for lids over 76"
- Remove surface rust with scotch-brite pad.

12. Final Inspection

To be completed by a different person than the previous steps.

dk

- Basket lid assembly for complete welds, and required minimum mesh weld locations.
- Material lists complete.
- Overall condition and conformity to drawing(s).

CARGO BASKET LID FABRICATION

Complete
(initial or SCA#)



13. Powder Coating

- a. Parts are to be powder coated white in accordance with commercial practices.
- b. Record powder coating PO.
- c. Inspect powder coating on receiving.
- d. Tag lid assembly and place into stock in preparation for assembly.

Work Order: 2014-42

Material Tracking Sheet
Bell 429 - S/N 57081 Sub.
Lid Fabrication

1 of 2

Date Opened: 17 Apr 14

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PC/WO
			95912-01	Lid Assembly		
Step 1				<i>Rim Assembly</i>		
	. 2		--	3/4" Tube - Long Rim (9' 0")	4130 Steel, 3/4" x .035 Sqr. Tube	14009
	. 2		--	3/4" Tube - Short Rim (22.5")	4130 Steel, 3/4" x .035 Sqr. Tube	13087
Step 2				<i>Weld Rim Assembly</i>		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	PO# 14033
Step 3				<i>Inspection - Rim</i>	None	
Step 4				<i>Frame Assembly</i>		
	. 4		--	3/4" Tube - Cross Member (21")	4130 Steel, 3/4" x .035 Sqr. Tube	12123
Step 5	. 10		--	1/2" Tube - walkway	4130 Steel, 1/2" x .035 Sqr. Tube	12123
Step 6				<i>Weld Frame Assembly</i>		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	PO# 14033
Step 7				<i>Inspection - Frame Assembly</i>	None	
Step 10				<i>Weld Lid Components</i>		
	. 1	84262	84262-01	Upper Handle Bracket Assembly		WO# 2014-38
	. 4		36273-01	Lid Bracket	321 Stainless, 0.050 Sheet	
	. 2		36275-02	Support	304 Stainless, 5/16" Rod	
	. A/R		--	Welding Rod	ER308L TIG Rod	PO# 14028
	. 1		49216-01	Spacer (Lid prop)	304 Stainless, 1/2" Dia.	WO# 2014-09
	. A/R		--	Welding Rod	ER308L TIG Rod	PO# 14028

Work Order: 2014-42

Material Tracking Sheet
Bell 429 - S/N 57081 Sub.
Lid Fabrication

2 of 2

Date Opened: 17 APR 2014

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PC/WO
Step 11				Clean Up		
Step 12				Inspection - Final Assembly		
Step 13				Powder Coating		



A/C or Part B429 RH PROTOTYPE BASKET
Work Order # 2014-42
Date 18 SEPT

[illegible]



Description: Basket Assembly Kit

WO#

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013

CARGO BASKET ASSEMBLY - COMMON

2014-42

B429 Later s/w RH Prototype

General

These instructions apply to all cargo basket assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only

69810, Revision 3 – Standard Low Mounted Basket

94510, Revision 0 – Extra-Wide Low Mounted Basket

94610, Revision 0 – Extra-Wide Low Mounted Ski Basket

76610, Revision 0 – High Mounted Ski Basket

Eurocopter AS350/AS355 – left or right

77610, Revision 1 – Short Basket

76410, Revision 3 – Medium Basket (left or right)

78410, Revision 2 – Long Basket

94010, Revision 0 – Extra Large (ski) Basket

Robinson R44 – left or right

90610, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only

80210, Revision 0 – Short Basket

80310, Revision 0 – Medium Basket

81110, Revision 0 – Long Basket

Bell 429 – right or left

95911, Revision 0 – Standard Basket

→ 95950, Rev 0 – Later s/w

Bell Medium – left or right

75111, Revision 0 – Standard Basket

95511, Revision 0 – Extra Large (ski) Basket

MD600

82811, Revision 0 – Standard Basket

Options

70405, Revision 3? – Lid Walkway

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #)

Work Order: 2014-42

Date Open: 7 Sep 14

A204

1. Lid Assembly

- a. Install lid bumpers on bottom.
 - i. Fill bumper holes with RTV silicone sealant.
 - ii. Insert 49205-14 lid bumper, 3 or 4 places per lid.
- b. Install placard on bracket on top of lid.
 - i. Locate placard on bracket.
 - ii. Drill #30 through placard and bracket, using holes in placard.
 - iii. Remove placard and de-burr holes in placard and on bracket.
 - iv. Locate placard on bracket, and cleco in place.
 - v. Rivet placard with four CR3213-4-02 CherryMax rivets.
- c. Option: Install walkway on top of lid (lid must be fitted with walkway provisions)
 - i. Note: avoid touching surface of tread plate with bare hands to prevent smudges or marks on the top surface.
 - ii. Pull tread plate from stock. Shear tread plate to length.
 - iii. De-burr edges of tread plate with scotch-brite disc on die-grinder.
 - iv. Locate tread plate on lid. Hold tread plate in place with bags of lead shot.
 - v. Mark and drill #30 holes:
 1. 0.25" from edge of tread plate, centre on cross members (0.38")
 2. 0.25" from edge of tread plate, middle of each walkway stringer
 - vi. De-burr and counter-bore (if required to provide clearance of rivet head on checker pattern) all holes in tread plate using 1/4" piloted counter bore on both sides.
 - vii. De-burr holes in lid tubes.
 - viii. Apply bead of RTV silicone sealant along all tubes under tread plate.
 - ix. Set tread plate in place, secure with clecos if necessary.
 - x. Rivet placard with CR3213-4-02 CherryMax rivets
- d. Record PO/WO of all parts (including lid) used in steps above on attached material tracking list.

2. Body Assembly

A206

- a. Install attachment fittings
 - i. Carefully remove excess powder coat from around attachment lug threads using a countersink.
 - ii. Run 3/8-24 tap into attachment lugs to clear threads.
 - iii. Apply anti-seize compound to attachment fittings 96710-01 (alternate: Ancra 40088-14)
 - iv. Install attachment fittings with two NAS1149F0363P washers in four lugs in basket.
 1. 90610 (Robinson R44) basket only:
 - a. Install 1 fitting 906?? in lower forward attachment lug only.
 - b. Install 3 96710-01 fittings in remaining locations.
 - v. Torque to ??

- b. 946 Basket Only: Install Cutout Brace – *must be completed after hinge installation*
 - i. Locate 94621-01 Brace over aft cross tube cutout
 - ii. Install two AN4-6A bolts and two AN4-30A bolts with NAS1149F0463P washers.
 - iii. Torque AN4 bolts to ??
- c. Record PO/WO of all parts (including basket) used in steps above on attached material tracking list.

AD06

3. Hinge Installation

- a. Prepare hinge.
 - i. Cut hinge to length:
 - 1. 776, 906 – 54"
 - 2. 751, 803 – 70"
 - 3. 698, 764, 945 – 72"
 - 4. 784 – 90"
 - 5. 940, 946, 959 – 95"
 - ii. Drill #30 pilot holes using hinge jig. For long hinges, flip at specified location on jig.
- b. Install hinge on basket
 - i. Locate hinge on basket (standard baskets)
 - 1. centre fore/aft
 - 2. 0.15" – 0.18" up from bottom edge
 - ii. Locate hinge on basket (extra wide baskets)
 - 1. centre fore/aft
 - 2. set hinge at 90 degrees (as if lid would be installed) using a small square, locate vertical side at 22.5" from outboard edge.
 - iii. Drill #30 through holes in hinge into basket rim. Cleco in place with 1/8 (copper) clecos.
 - iv. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 (black) clecos.
 - v. Remove hinge and de-burr holes in hinge and basket rim.
 - vi. Cleco hinge to basket with 5/32 clecos.
 - vii. Install hinge with CherryMax rivets
 - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
 - 2. CR3213-5-02 aluminum rivets – all other locations
- c. Install lid on basket
 - i. Locate lid on hinge (all baskets)
 - 1. center fore/aft
 - 2. 0.15" – 0.18" down from top edge
 - ii. Drill #30 through holes in hinge into lid rim. Cleco in place with 1/8 clecos.
 - iii. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 clecos.
 - iv. Remove hinge and de-burr holes in hinge and lid rim.
 - v. Cleco lid to hinge with 5/32 clecos.
 - vi. Install hinge with CherryMax rivets
 - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
 - 2. CR3213-5-02 aluminum rivets – all other locations

- d. Record PO of hinge and rivets on attached material tracking list.

4. Install Handle

ADOL

- a. Install handle brackets.
- Set 84267-01 handle bracket on provisions in hoops, 2 places.
 - Install AN3-11A bolt, NAS1149F0363P washer (2), MS21044N3 nut. Two places per bracket, two brackets per basket.
 - Torque AN3 bolts to ??.
- b. Install handle
- Trim 36278-01R and 36278-01L springs to ensure end of spring does not extend past edge of handle bracket, approximately 1/8". Set springs over bushing of 84261-01 handle assembly.
 - Grease two 36275-01 bushings with ?? Insert into bushings of handle assembly.
 - Locate handle on basket lid. Insert AN3-12A bolt with NAS1149F0363P through bracket on lid and handle bushing on one end of handle.
 - On other end of handle, hook spring over catch rivet on handle assembly and use spring tool to twist spring to catch arm on bracket on lid while inserting AN3-12A bolt with NAS1149F0363P washer through lid bracket and handle bushing.
 - At first end, remove bolt and repeat step iv.
 - Install NAS1149F0363P washer and MS21044N3 nut on both AN3-12A bolts.
 - Torque AN3 bolts to ??.
- c. Check handle
- Operate handle to ensure handle does not bind and springs hold handle in.
 - Snap handle into brackets to ensure handle locks.
- d. Record PO/WO of all parts used in steps above on attached material tracking list.

5. Install lid brace

ADOL

- a. Locate 36280-01 lid brace on bushing in basket. Ensure brace is on forward end of basket as it will be installed on the helicopter.
- b. On lid end, insert AN970-3 washer into end of lid brace. Insert AN3-15A bolt with NAS1149F0363P washer through AN970-3 washer, lid prop, and lid bushing. Install NAS1149F0363P washer and MS21044N3 nut on bolt.
- c. On basket end, insert AN3-17A bolt with AN970-3 washer through lid prop and basket bushing. Install NAS1149F0363P washer and MS2144N3 nut on bolt.
- d. Ensure brace is seated on lip of bushings before tightening nuts.
- e. Torque AN3 bolts to ??
- f. Record PO/WO of all parts used in steps above on attached material tracking list.

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #)

OK

6. Final Inspection

Dual inspection by a different person than assembled the basket.

- a. Check for general condition and correct assembly:
 - i. Bolts are tight
 - ii. Rivets are installed correctly
 - iii. Handle operates correctly
 - iv. Lid brace operates correctly
- b. Check that PO/WO numbers have been recorded.

Work Order: 2014-42

Material Tracking Sheet
Bell 429 - S/N 57081 Sub.
Basket Assembly

1 of 2

Date Opened: _____

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>1</u>		95950-01- <u>01</u>	Cargo Basket Assembly	(-01 RH, -02 LH)	
Step 1				<i>Lid Assembly</i>		
Step 1.a.	. 1		95912-01-XX	Basket Lid Assembly		
	. . 4		49205-14	Bumper	Argus Industries Bumper	11010
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	
	. . 1		95917-XX	Lid Checker Plate	3003 Aluminum Tread Plate, 0.063"	3066
	. . A/R		CR3213-4-02	Cherry Rivet		14032
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	
Step 2				<i>Basket Assembly</i>		
Step 2.a.	. 1		95911-01-XX	Basket Body Assembly		
	. . 4		96710-01	Fitting	Alternate: Ancra 40088-14	13042
	. . 8		NAS1149F0663P	Washer		13084
	. . 1		95915-01	Forward Sheet		
	. . 1		95916-01	Forward Filler Sheet		
	. . 1		95916-02	Aft Filler Sheet		
	. . 1		95927-01-XX	Placard	0.063 Sheet, 6061-T6 Aluminum	
	. . A/R		CR3213-4-02	Cherry Rivet		14032
Step 3				<i>Hinge Installation</i>		
	. 1		MS20001P4	Piano Hinge	95"	13089
	. 8		CR3523-5-02	Cherry Rivet		13026
	. A/R		CR3213-5-02	Cherry Rivet		14001
Step 4	. 1		84255-01	<i>Handle Installation</i>		
Step 4.a.	. . 2		84267-01	Bracket	Delrin, 3/4" Sheet	2014-48
	. . 4		AN3-11A	Bolt		14001
	. . 8		NAS1149F0363P	Washer		13084
	. . 4		MS21044N3	Nut		13083

Work Order: 2014-42Material Tracking Sheet
Bell 429 - S/N 57081 Sub.
Basket Assembly

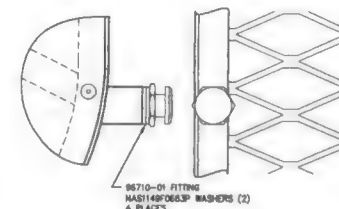
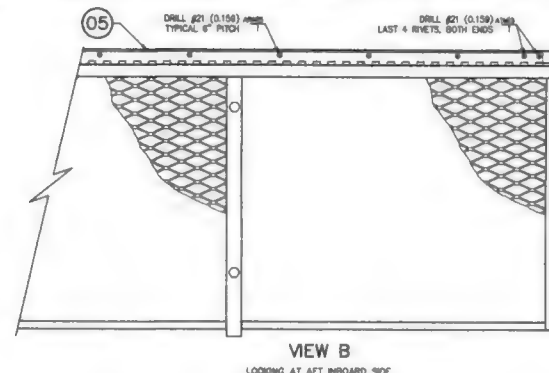
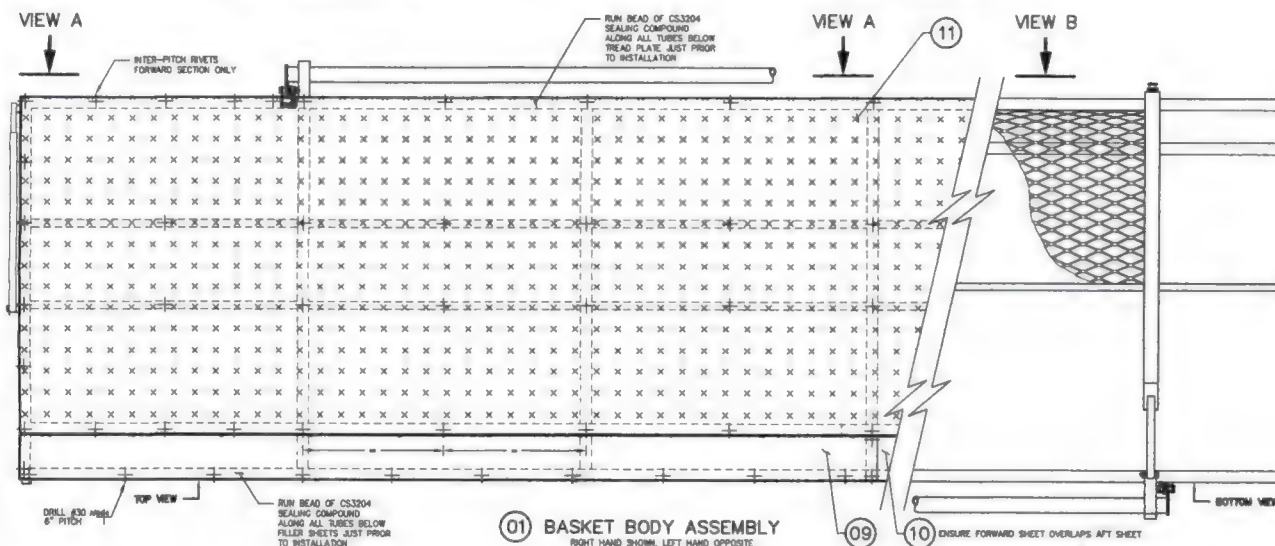
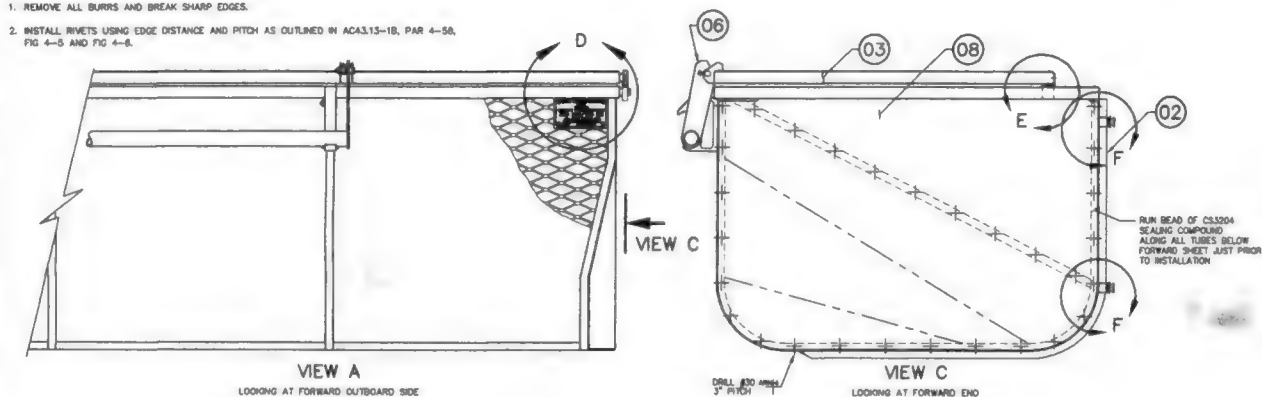
2 of 2

Date Opened: _____

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 4.b.	.. 1		84261-01	Handle Assembly		
	.. 2		36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	13015 13085
	.. 2		36275-01	Bushing	Brass, 5/16" Dia	203-33
	.. 2		AN3-12A	Bolt	13084	
	.. 4		NAS1149F0363P	Washer	14048	
	.. 2		MS21044N3	Nut	✓ 13083	
Step 5				Lid Brace Installation		
	. 1		36280-01	Brace Assembly	2014-88	
	. 1		AN3-15A	Bolt	13084	
	. 1		AN3-17A	Bolt	13084	
	. 2		AN970-3	Washer	13083	
	. 3		NAS1149F0363P	Washer	14048	
	. 2		MS21044N3	Nut	13083	
Step 6				Inspection	None	

NOTES

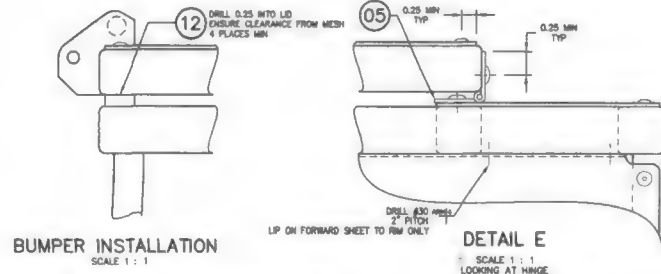
1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. INSTALL RIVETS USING EDGE DISTANCE AND PITCH AS OUTLINED IN ACA313-1B, PAR 4-5B, FIG 4-5 AND FIG 4-6.



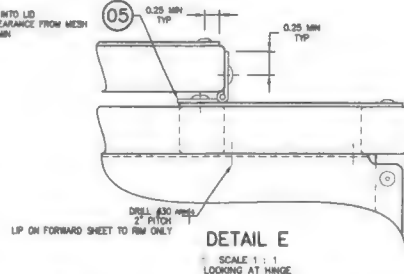
DETAIL F

SCALE 1 : 1
LOOKING AT FORWARD LOWER ATTACHMENT, UPPER ATTACHMENT SIMILAR
REAR ATTACHMENTS SIMILAR

A/R/A/R	CS3204	SEALING COMPOUND	AMS-5-8822C T2 B1/2
B B	HAST140F083P	WASHER	
4 4	96710-01	FITTING	ALT: AMORA 40088-14
A/R/A/R	CR3213-4-02	CHERRY RIVET	ALT: HR3213-4-02
6 6	CR3213-5-02	CHERRY RIVET	ALT: HR3213-5-02
A/R/A/R	CR3213-5-02	CHERRY RIVET	ALT: HR3213-5-02
4 4	49205-14	BUMPER	ARGUS INDUSTRIES
1 1	95917-01	LH LID CHECKER PLATE	
1 1	95917-01	RH LID CHECKER PLATE	
1 1	95918-02	AFT FILLER SHEET	
1 1	95918-01	FORWARD FILLER SHEET	
1 1	95955-02	LH FORWARD SHEET	
1 1	95955-01	RH FORWARD SHEET	
1 1	95927-04	LH PLACARD	
1 1	95927-03	RH PLACARD	
1 1	84235-01	HANDSILE BAN INSTRUMENT	
1 1	M52001P4	PIANO HINGE	90° LONG
1 1	84240-01	LID BRACE INSTALLATION	
1 1	95912-01-02	LH LID ASSEMBLY	
1 1	95912-01-01	RH LID ASSEMBLY	
1 1	95951-01-02	LH BASKET BODY ASSEMBLY	
1 1	95951-01-01	RH BASKET BODY ASSEMBLY	
1 1	95950-01-02	LH CARGO BASKET ATTACHMENT	
1 1	95950-01-01	RH CARGO BASKET ATTACHMENT	
-02 -01			
QTY	QTY	PART NO.	ITEM
LIST OF MATERIALS			
MATERIAL			



BUMPER INSTALLATION
SCALE 1 : 1



DETAIL E
SCALE 1 : 1
LOOKING AT HINGE

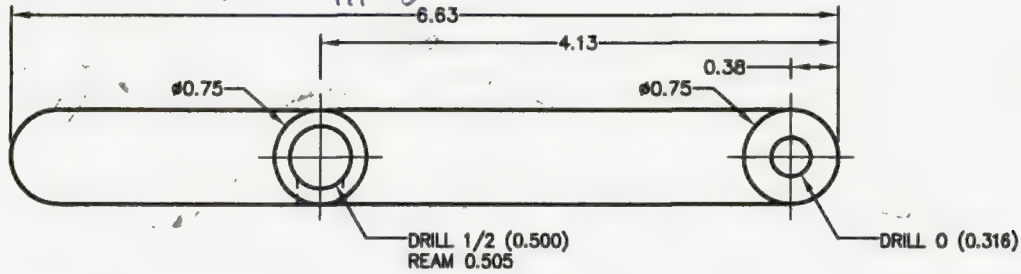


DETAIL D
SCALE 1 : 1
LOOKING AT PLACARD BRACKET

BASIC CODE	DASH NO. FOR DIAMETER	APPROVALS	DATE
REF: HAS 523	N=MPD. HEAD NEAR SIDE	DRAWN: JEFF CLARKE	20 FEB 2014
	F=MPD. HEAD FAR SIDE	CHECKED: JASON REKVE	
C=COUNTERSINK	D=DIMPLE	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.	
DIGIT=9 OF SHEETS TO BE DIMPLED	DASH NO. FOR LENGTH	TOLERANCES ON:	
		DECIMALS ANGLES	
		X.XXX ±0.010	
		X.XX ±0.03	
		X.X ±0.1	
		±1/2"	
		INSTALL NEW RIVET	
		REMOVE/REPLACE RIVET	
		EXISTING RIVET	

QTY	QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL
LIST OF MATERIALS					
MATERIAL					
AERO DESIGN LTD.					
9666A MANABIA ROAD					
PORTER, RIVER, BC, CANADA, V8C 0G5					
TEL: 604.688.8870					
WWW.AERODESIGN.CO					
BELL 429 - S/N 57081 & SUB.					
QUICK RELEASE CARGO BASKET					
CARGO BASKET ASSEMBLY					
SCALE 1 : 4					
SHEET 1 OF 1					
A1 95950 0					

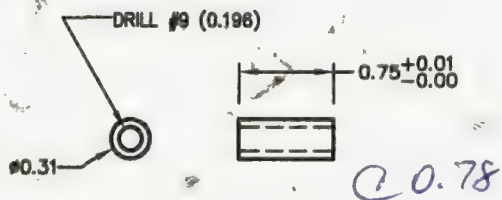
Po # 11125



(11) LEVER

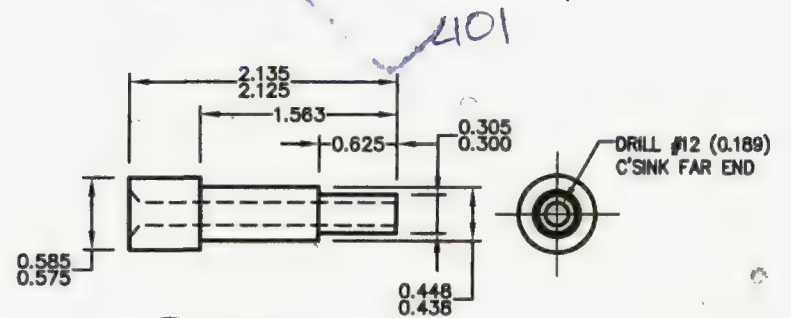
1.0 SAE x 6.75 long 6061

x1



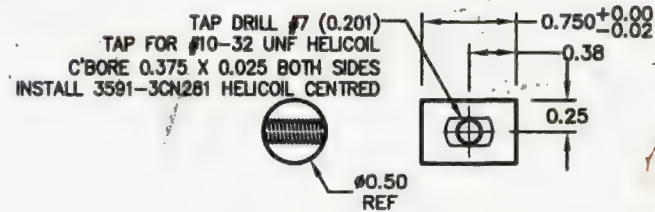
(13) BUSHING

Brass
Po # 13052 x1



(10) STOP

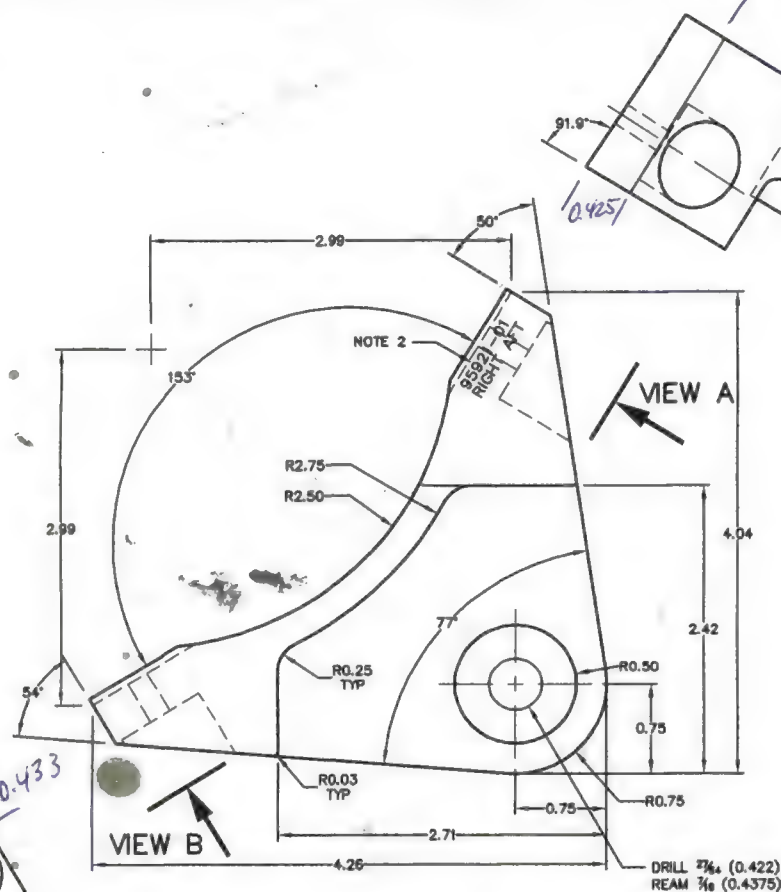
5/8 6061 x1



(12) BARREL NUT

Po 13050 x1

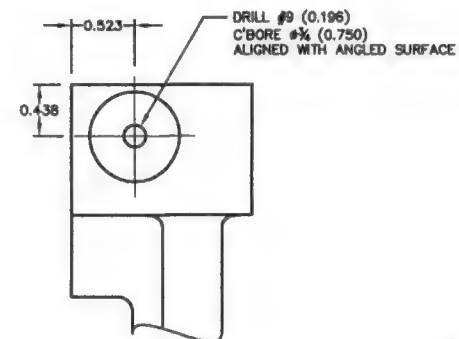
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		



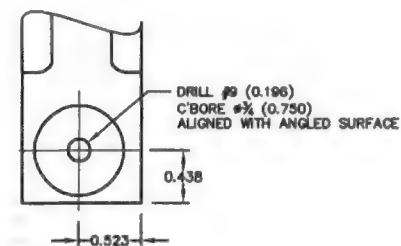
- 01 RIGHT HAND AFT FITTING
02 LEFT HAND AFT FITTING
RIGHT HAND SHOWN, LEFT HAND OPPOSITE

NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. ENGRAVE PART NUMBER 0.080 HIGH, 0.007 DEEP, LOCATED AS SHOWN.
3. THOROUGHLY DEGREASE, ALODINE, EPOXY PRIME AND POLYURETHANE PAINT ALL ALUMINUM PARTS PRIOR TO ASSEMBLY.
ALTERNATE: ALUMINUM PARTS TO BE ANODIZED IN ACCORDANCE WITH MIL-A-8625F, TYPE III.



VIEW A
DIMENSIONS AT BOTTOM SURFACE



VIEW B
DIMENSIONS AT BOTTOM SURFACE

1	95921-02	02	LEFT HAND AFT FITTING	6061-T6 ALUMINUM	QQ-A-200/B	4 X 2 BAR
1	95921-01	01	RIGHT HAND AFT FITTING	6061-T6 ALUMINUM	QQ-A-200/B	4 X 2 BAR
	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					

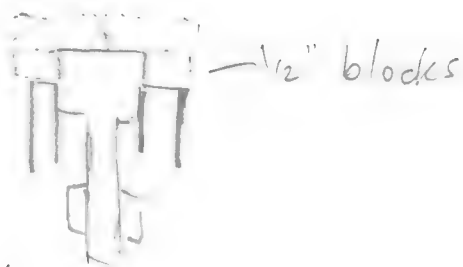
<div>NOTICE</div> <div>THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THE DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR ANY PURPOSES WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. ANY REUSE OF THIS DRAWING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. SHALL BE AT THE USER'S SOLE RISK. AERO DESIGN LTD. MAKES NO WARRANTY, OR WAIVER, OF ANY KIND, OR ASSUMES ANY LIABILITY FOR THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREIN.</div>	APPROVALS	DATE	<div>AERO DESIGN LTD.</div> <div>CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2018 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 250-8087 fax: (403) 250-8333 www.aerodesign.ca</div>
	DRAWN: JEFF CLARKE	21 SEPT 2012	
	CHECKED: E. BURGON	10 NOV 2012	
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1		
	SCALE 1 : 1		

SHEET 1 OF 1		DWG. SIZE	DWG. NO.	REV.
A3		95921	0	

1. Rotate head down
 $1.9^\circ / 3.3^\circ$



2. Set part level w/ vise



3. Face ~~the~~ large shell mill



4. Touch off far side for Y, part edge for X

for 3.3° face \rightarrow touch off far side, 0, -1.25, 0, +0.523



5. Drill #9 holes through.

6. Flip part, locate on #9 drill for alignment
align vise to part

7. Counter Bore $\phi \frac{3}{4}$ to $\frac{3}{8}$ inch thick.

02

DRILL $\phi 5/8$ (0.625) THRU

08

DRILL F (0.257)
2 PLACES

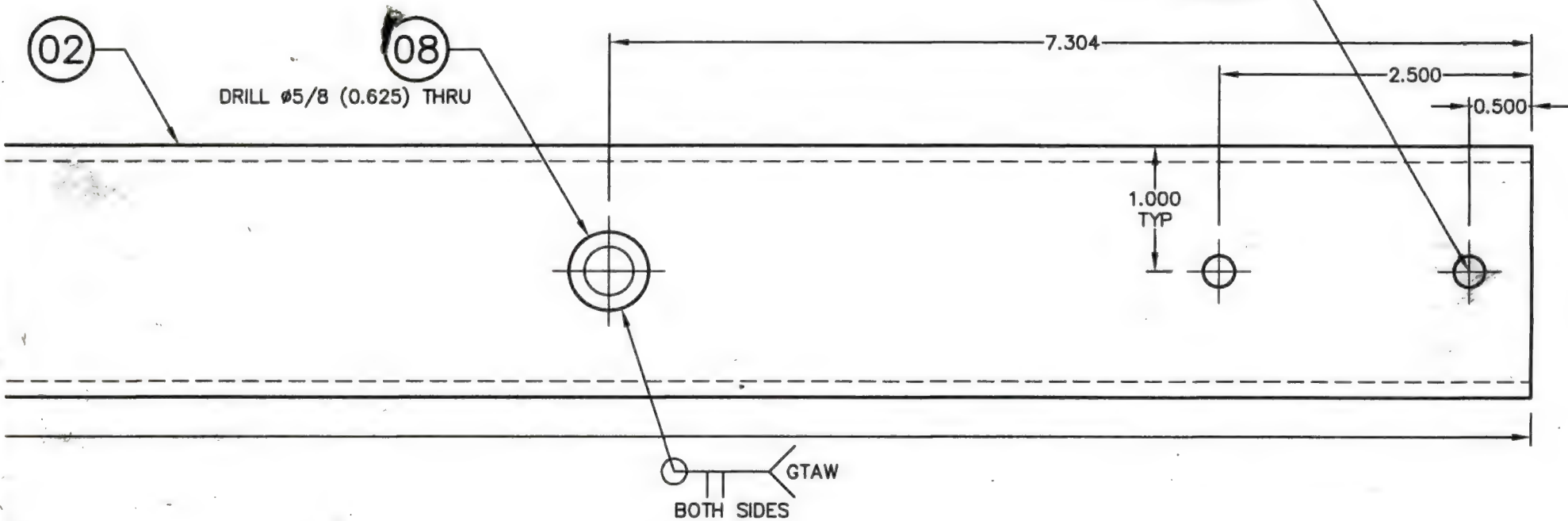
7.304

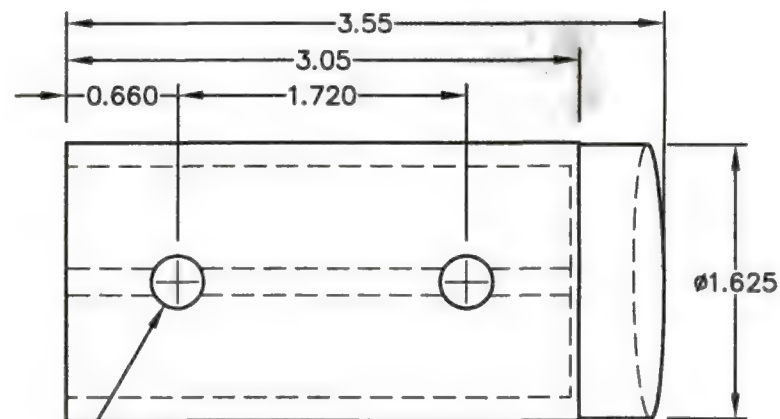
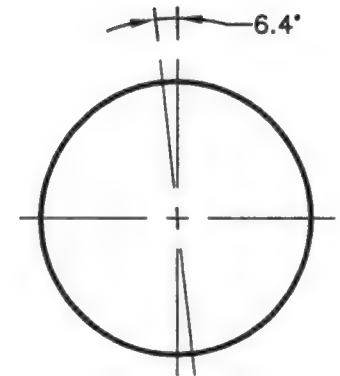
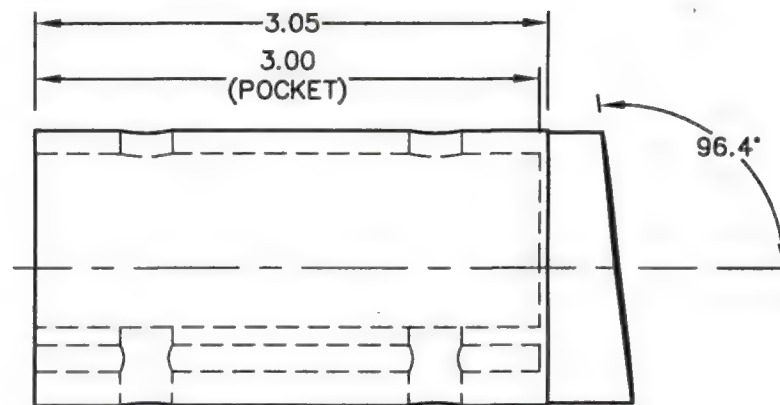
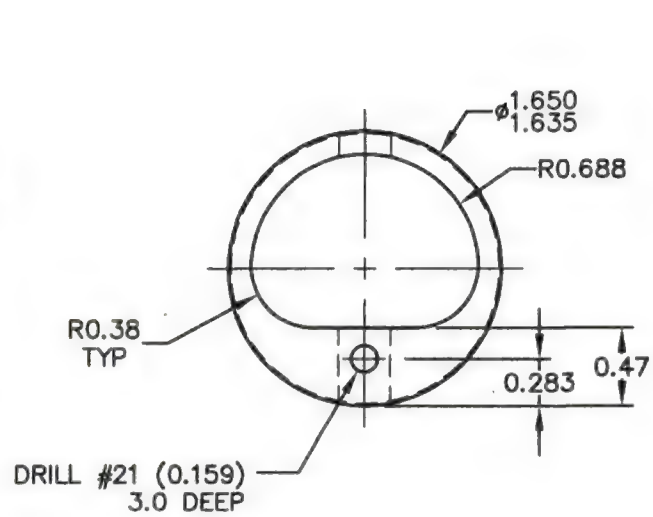
2.500

0.500

1.000
TYP

GTAW
BOTH SIDES





DRILL P (0.323) THRU
2 PLACES

(05) CENTRE RH PLUG
(06) CENTRE LH PLUG

3424 Post s/w & Fittings

Setup Notes

Rotate vise 6.4° CW = LH CCW = RH

Rotate head towards operator 6.35°

* ensure head is aligned to Y axis *

Set $\emptyset X$



1 touch one side, set $\emptyset X$

2 touch other side (2.125 nom)

3 Split reading from 2 (1.063 nom)
set $\emptyset X$

Set $\emptyset Y$



touch close side, set $\emptyset Y$

Set $\emptyset Z$

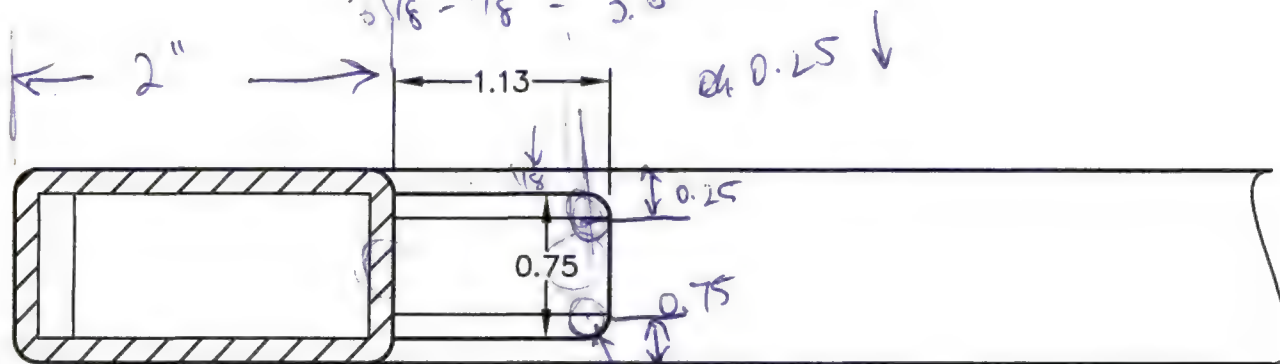


with cutter @ XO Y 1.063 touch
top.

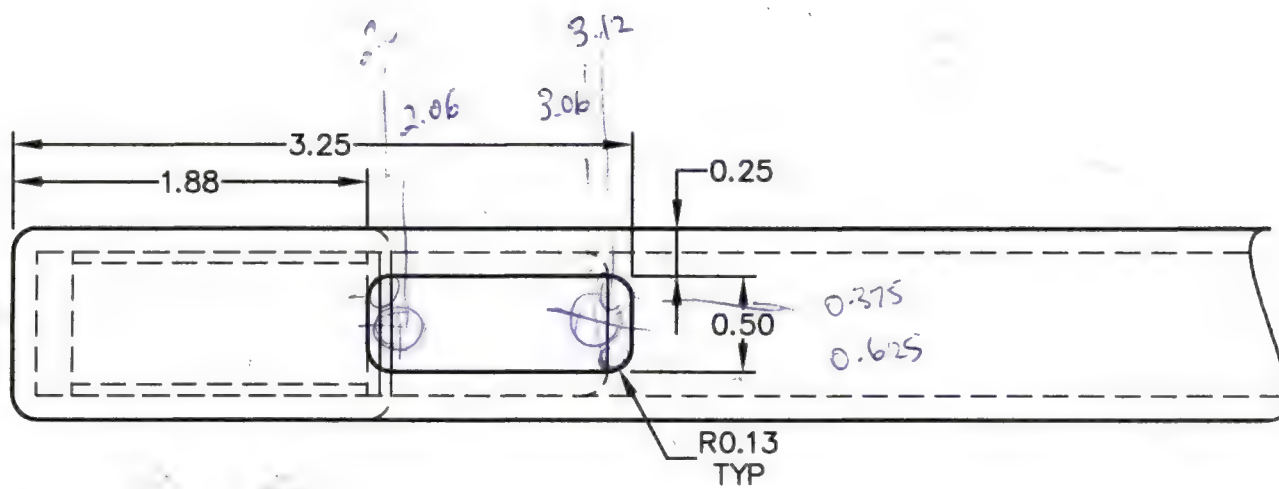
65.00" long

$$3\frac{1}{8} - \frac{1}{4} = 2\frac{7}{8}$$

$$3\frac{1}{8} - \frac{1}{8} = 3.0$$



SECTION A-A



1x2 x 1/8 wall

65"



X2

B429

1/8 1x2 x 0.120

13077

7.304

5.594

1.710

27.80

26.09

DRILL F (0.257)
2 PLACES

7.304

2.500

0.500

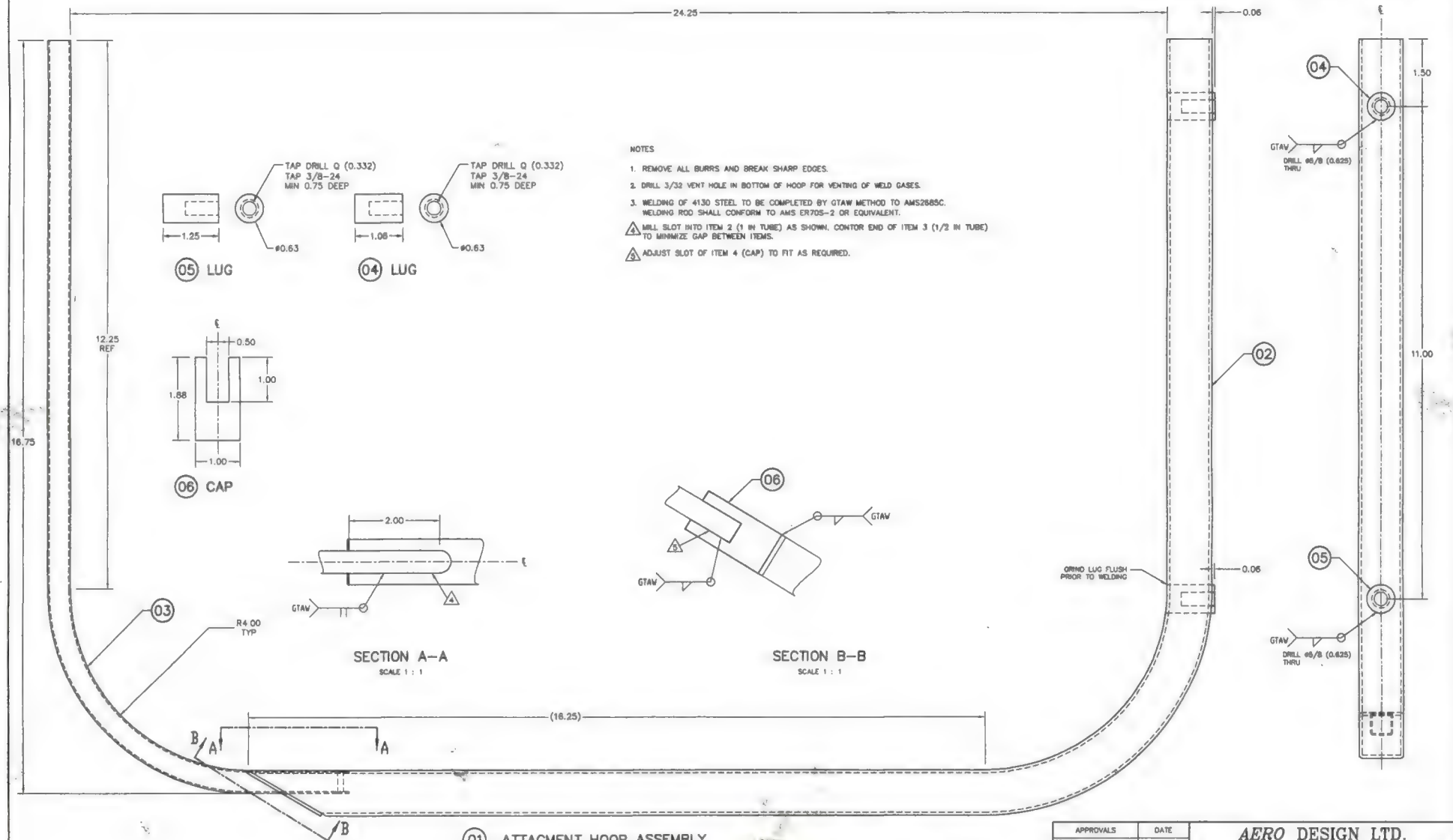
1.000
TYP

$\phi 5/8$

GTAW

BOTH SIDES
TYPICAL, 5 PLACES

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		



01 ATTACHMENT HOOP ASSEMBLY

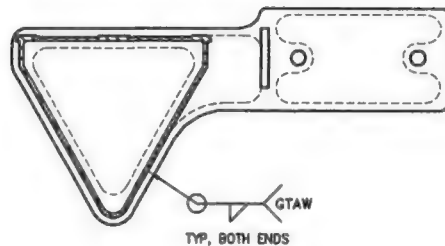
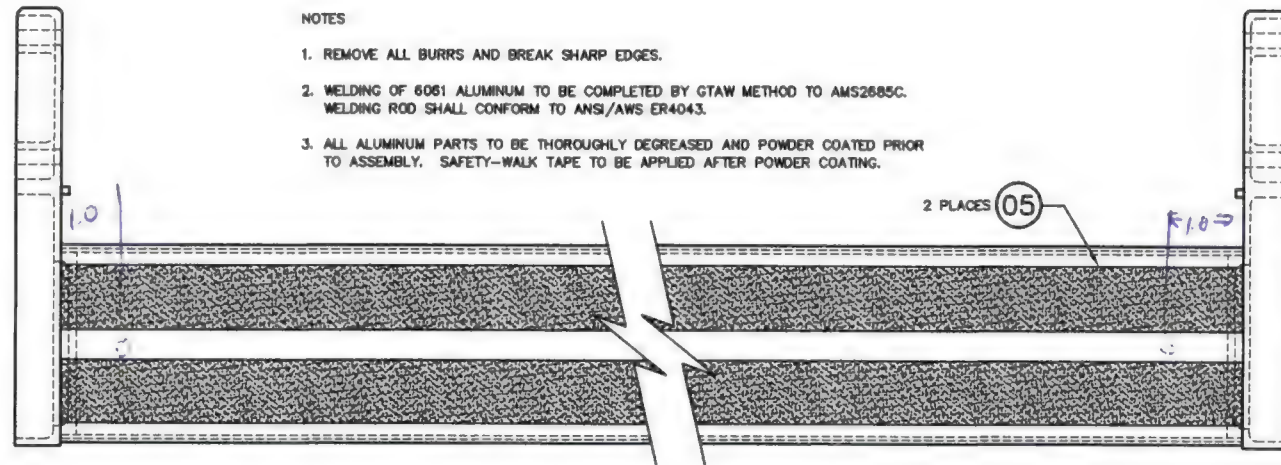
QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	95928-06	06	CAP	1018 MILD STEEL	ANSI 1010/1020	0.032 SHEET OR STRIP
1	95928-05	05	LUG	1018 MILD STEEL	ANSI 1010/1020	5/8 DIA ROD
1	95928-04	04	LUG	1018 MILD STEEL	ANSI 1010/1020	5/8 DIA ROD
A/R	03	03	TUBE 1/2IN	4130 STEEL COND. N	MIL-T-8736	1/2 X 0.035 SQR TUBE
A/R	02	02	TUBE 1IN	4130 STEEL COND. N	MIL-T-8736	1 X 0.065 SQR TUBE
01	95928-01	01	ATTACHMENT HOOP ASSEMBLY	4130 STEEL COND. N	MIL-T-8736	1 X 0.065 SQR TUBE

APPROVALS	DATE	AERO DESIGN LTD.	
DRAWN: JEFF CLARKE	12 SEPT 2012	CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR ROOM	
CHECKED: E. BURTON	10 NOV 2012	3018 - 50TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6S7	
		Tel: (403) 260-8007 Fax: (403) 260-8100 www.aerodesign.ca	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1		BELL 429 QUICK RELEASE CARGO BASKET ATTACHMENT HOOP FABRICATION	
SCALE 1:1		DWG. SIZE	DWG. NO.
SHEET 1 OF 1		A1	95926 0

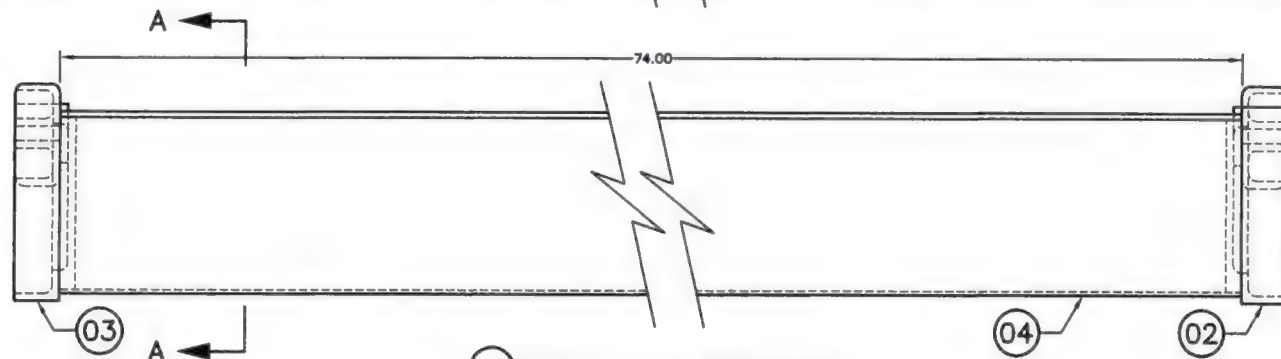
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		

NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. WELDING OF 6061 ALUMINUM TO BE COMPLETED BY GTAW METHOD TO AMS2685C. WELDING ROD SHALL CONFORM TO ANSI/AWS ER4043.
3. ALL ALUMINUM PARTS TO BE THOROUGHLY DEGREASED AND POWDER COATED PRIOR TO ASSEMBLY. SAFETY-WALK TAPE TO BE APPLIED AFTER POWDER COATING.



SECTION A-A



(01) FIXED STEP ASSEMBLY

QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL
2	96910-05	05	SAFETY-WALK TAPE (1" WIDE)	3M
A/R	78240	04	STEP EXTRUSION	
1	96920-02	03	LH BRACKET	
1	96920-01	02	RH BRACKET	
	96910-01	01	FIXED STEP ASSEMBLY	

LIST OF MATERIALS

NOTICE: THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DISCLOSED IN ANY MANNER, NOR USED FOR ANY PURPOSE, WITHOUT THE WRITTEN PERMISSION OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR ABUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED HEREIN.

APPROVALS	DATE
DRAWN: JEFF CLARKE	14 SEPT 2012
CHECKED: E. BURGOIN	04 DEC 2012

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES.
TOLERANCES ON:
DECIMALS ANGLES
X.XXX ±0.010 ±1/2°
X.XX ±0.03
X.X ±0.1

AERO DESIGN LTD.			
CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 280M 2015 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 250-8087 fax: (403) 250-9335 www.aerodesign.ca			
BELL 429 CABIN STEP INSTALLATION FIXED STEP ASSEMBLY			
SCALE 1 : 2	DWG. SIZE A3	DWG. NO. 96910	REV. 0
SHEET 1 OF 1			

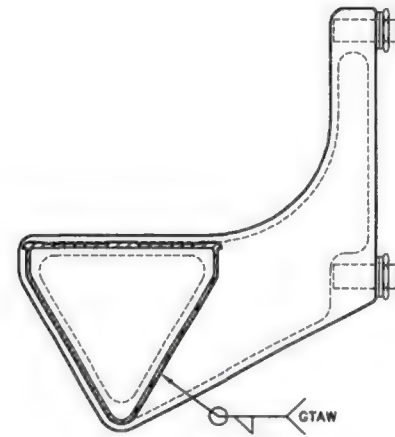
THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREON.

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	.	.

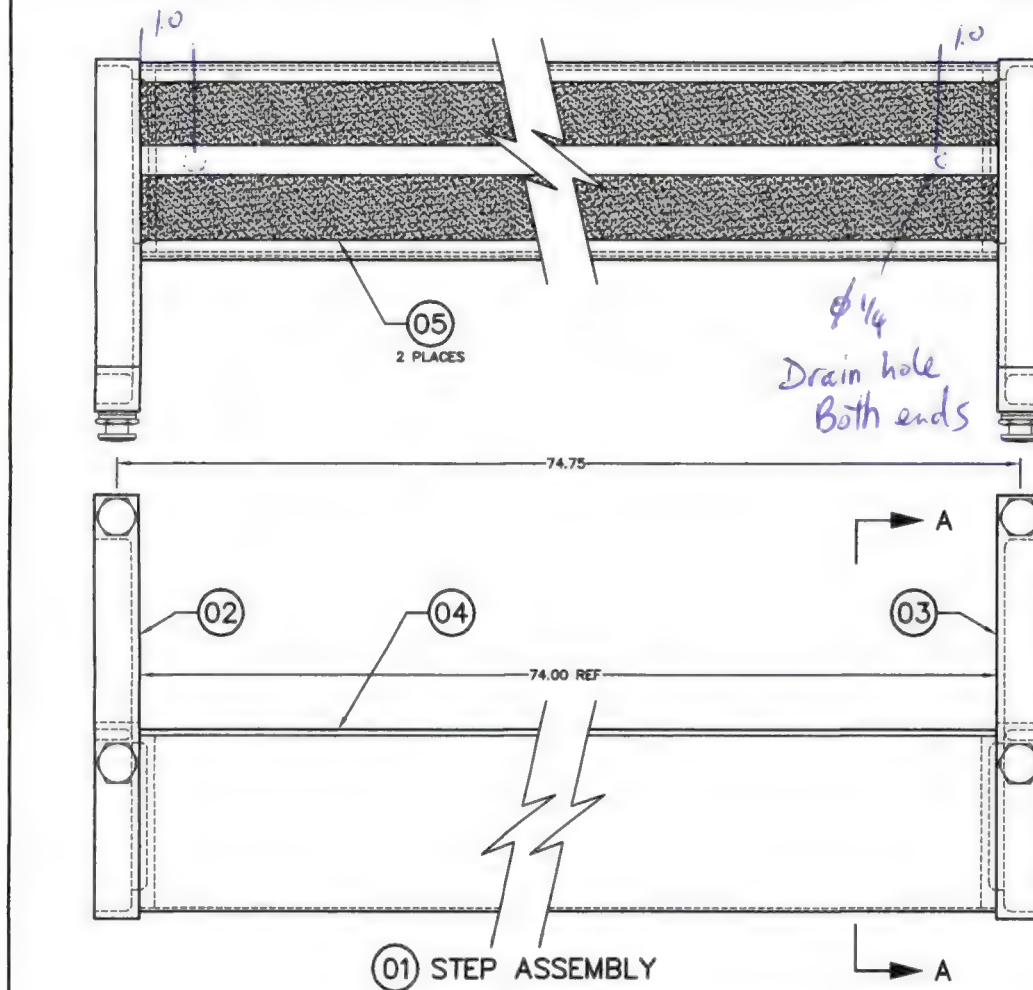
NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. WELDING OF 6061 ALUMINUM TO BE COMPLETED BY GTAW METHOD TO AMS2685C. WELDING ROD SHALL CONFORM TO ANSI/AWS ER4043.
3. ALL ALUMINUM PARTS TO BE THOROUGHLY DEGREASED AND POWDER COATED PRIOR TO ASSEMBLY. SAFETY-WALK TAPE TO BE APPLIED AFTER POWDER COATING.

40088-14 STUD FITTING
NAS1149F0663P WASHER (2)
4 PLACES



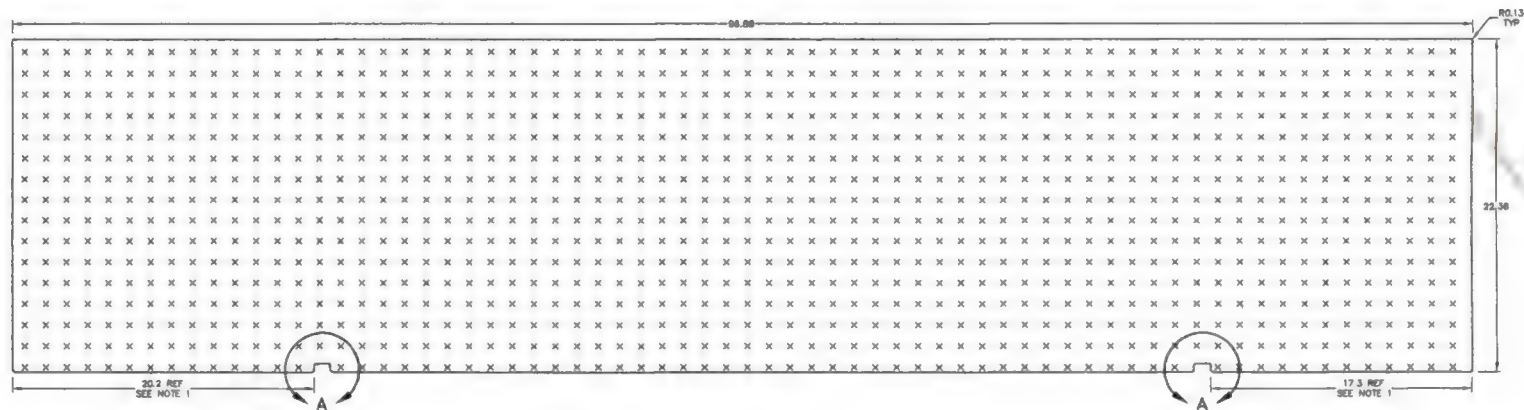
SECTION A-A



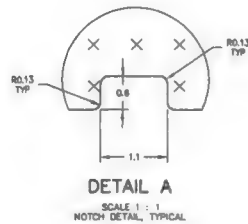
QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL
8	NAS1149F0663P		WASHER	
4	40088-14		STUD FITTING	ANCR4
2	96911-05	05	SAFETY-WALK TAPE (1" WIDE)	3M
A/R	78240	04	EXTRUSION	
1	96921-02	03	LH STEP BRACKET	
1	96921-01	02	RH STEP BRACKET	
	96911-01	01	STEP ASSEMBLY	

APPROVALS	DATE	AERO DESIGN LTD.			
DRAWN: JEFF CLARKE	28 NOV 2012	CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M			
CHECKED: E. BURGAIN	04 DEC 2012	2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7			
		tel: (408) 850-8027 fax: (408) 850-8335 www.aerodesign.ca			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1		BELL 429 QUICK RELEASE CABIN STEP STEP ASSEMBLY			
SCALE 1 : 2		DWG. SIZE	DWG. NO.	REV.	
SHEET 1 OF 1		A3	96911	0	

THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THE DRAWING OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE ACCEPTOR AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREON.			
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		



(01) LID CHECKER PLATE
RIGHT HAND SHOWN, LEFT HAND OPPOSITE



NOTES

1. LOCATION OF NOTCHES TO FIT LID ASSEMBLY 95912-01.
2. REMOVE ALL BURRS AND BREAK SHARP EDGES.

1	95917-02	01	LH LID CHECKER PLATE	3003 ALUMINUM	COMMERCIAL	G.083" C-102 CHECKER
1	95917-01	01	RH LID CHECKER PLATE	3003 ALUMINUM	COMMERCIAL	G.083" C-103 CHECKER
Q1	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
LIST OF MATERIALS						
AERO DESIGN LTD.						
CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR ROOM 2015 - 80TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2C 0B7 Tel: (403) 244-5887 Fax: (403) 244-5888 www.aerodesign.ca						
BELL 429						
QUICK RELEASE CARGO BASKET						
LID CHECKER PLATE FABRICATION						
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:			DECIMALS X.00X ±0.010 X.XX ±0.03 X.X ±0.1			
			ANGLES ±1/2"			
SCALE 1 : 4			SHEET 1 OF 1			
DWG. SIZE			DWG. NO.			
A1			95917			
REV.			0			

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		



02 BUSHING



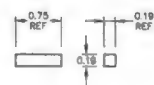
01 BUSHING

NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.

4	95922-02	02	BUSHING	BRASS	ASTM B927	0.375 ROD
2	95922-01	01	BUSHING	BRASS	ASTM B927	0.438 ROD
	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					
<p>NOTICE</p> <p>THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. ANY REUSE OF THIS DRAWING FOR ANY PURPOSE, WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. WILL BE AT THE USER'S RISK. THE USER AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREIN.</p>				<p>APPROVALS</p> <p>DRAWN: JEFF CLARKE 12 SEPT 2012</p> <p>CHECKED: E. BURGON 10 NOV 2012</p>		
				<p>DATE</p>		
				<p>UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:</p> <p>DECIMALS ANGLES</p> <p>X.XXX ±0.010 ±1/2°</p> <p>X.XX ±0.03</p> <p>X.X ±0.1</p>		
				<p>AERO DESIGN LTD.</p> <p>CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M</p> <p>2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7</p> <p>tel: (403) 260-8087 fax: (403) 260-8083 www.aerodesign.ca</p>		
				<p>BELL 429</p> <p>QUICK RELEASE CARGO BASKET</p> <p>BUSHINGS FABRICATION</p>		
				SCALE 1 : 1	DWG. SIZE	DWG. NO.
					A3	95923
				SHEET 1 OF 1		0

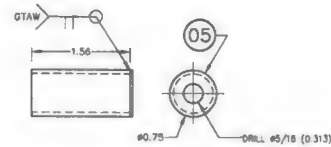
THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, AND USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREIN.			
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		



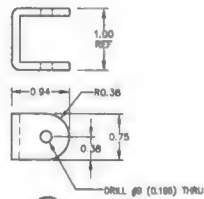
06 BLOCK



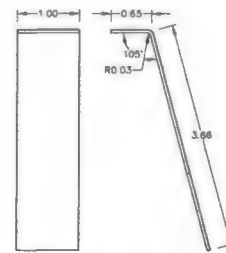
05 CAP



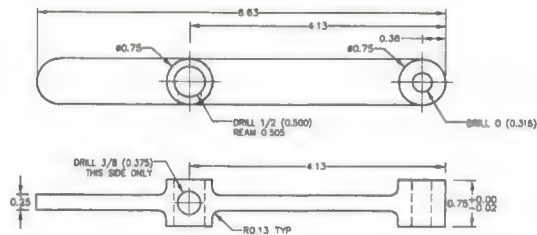
04 GUIDE



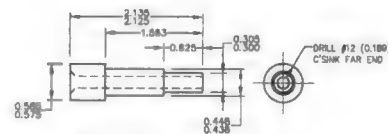
09 TAB



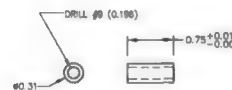
07 CAP



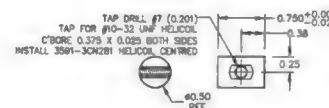
11 LEVER



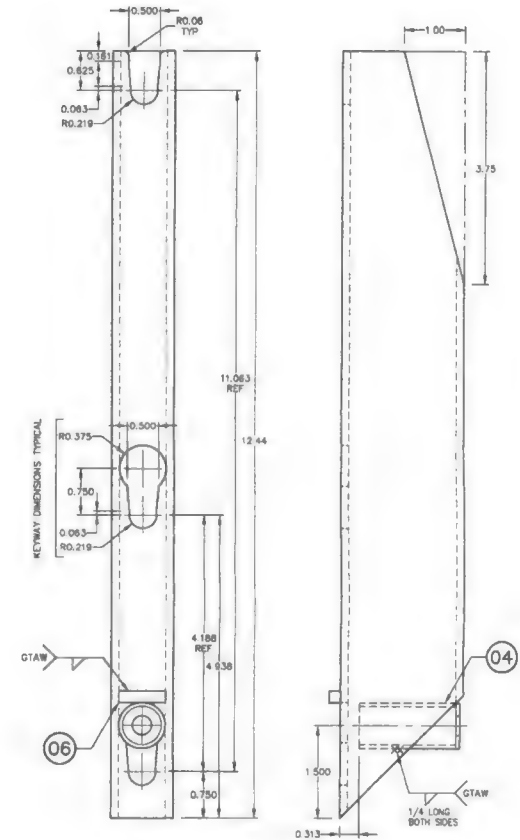
10 STOP



13 BUSHING

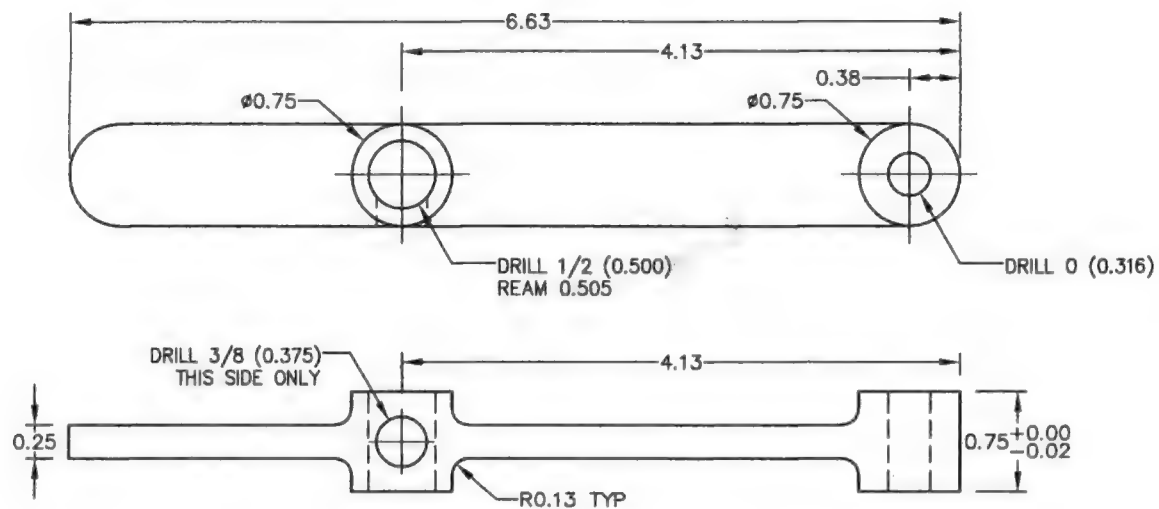


12 BARREL NUT

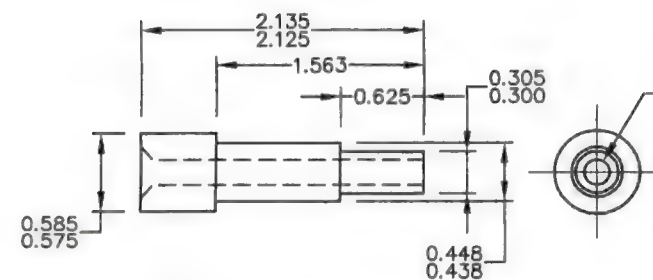


03 DOWN TUBE

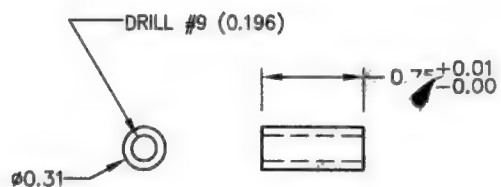
APPROVALS		DATE	AERO DESIGN LTD. CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAB 890M 5018 - 80TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 Tel: (403) 880-8887 Fax: (403) 880-8883 www.aerodesign.ca	
DRAWN	JEFF CLARKE	05 SEPT 2012		
CHECKED	E. BURGON	10 NOV 2012	BELL 429 QUICK RELEASE CARGO BASKET AFT BEAM FABRICATION	
UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES. TOLERANCES ON:			SCALE 1:1	REV.
DECIMALS			A1	95931
X.XXX ±0.010			2	0
X.XX ±0.03				
X.X ±0.1				



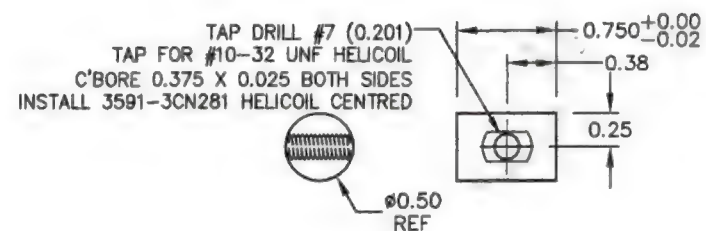
(11) LEVER



(10) STOP



(13) BUSHING



(12) BARREL NUT

0.0

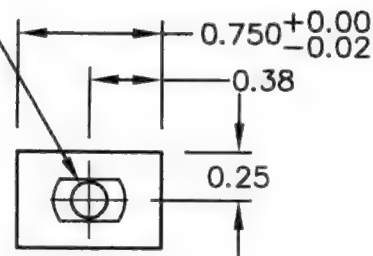
4.132



TAP DRILL #7 (0.201)
TAP FOR #10-32 UNF HELICOIL
C'BORE 0.375 X 0.025 BOTH SIDES
INSTALL 3591-3CN281 HELICOIL CENTRED



ø0.50
REF



Part #
3591-3EN190

Part # 13079
installed

(12) BARREL NUT

3.6295

4.6345

.5025



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity: 1

PN: 95940-03

Aircraft: Bell

Model: 429

Description: Mount (Long) RH AFT

Supplier: Aero Design

Color: Black

WO#: 2014-42

PO# N/A



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity: 1

PN: 95932-01-01

Aircraft: Bell

Model: 429

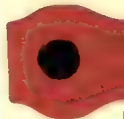
Description: R.H. Forward Beam

Supplier: Aero Design

Color: White

WO#: 2014-42

PO# N/A





Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity:

1

PN:

95942-02

Aircraft:

Bell

Model: 429

Description:

Plate

Supplier:

Aero Design

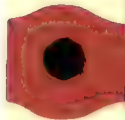
Color:

Black

VO#:

2014-42

PO# N/A





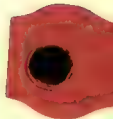
Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity: 1
PN: 95931-01
Aircraft: Bell
Description: AFT Beam
Supplier: Aero Design
Color: White
WO#: 2014-42

Model: 429

PO# N/A





Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity:

1

PN:

95940-01

Aircraft:

Bell

Model: 429

Description:

Mount (Short) *RH FWD*

Supplier:

Aero Design

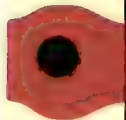
Color:

Black

WO#:

2014-42

PO# N/A





Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity:

1

PN:

95940-06

Aircraft:

Bell

Model: 429

Description:

Mount LH CEN

Supplier:

Aero Design

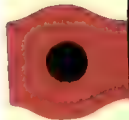
Color:

Black

WO#:

2014-42

PO# N/A





Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity: 1

PN: 95940-05

Aircraft: Bell

Model: 429

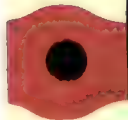
Description: Mount *RH CEN*

Supplier: Aero Design

Color: Black

WO#: 2014-42

PO# N/A

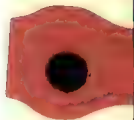




Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity:	1	
PN:	95940-02	
Aircraft:	Bell	Model: 429
Description:	Mount (Short) LH Fwd	
Supplier:	Aero Design	
Color:	Black	
WO#:	2014-42	PO# N/A





Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity:	2
PN:	84267-01
Description:	Cargo Basket Handle Bracket
Supplier:	Aero Design
PO#:	
WO#:	2014-48



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity: 1

PN: 95942-02

Aircraft: Bell

Model: 429

Description: Plate

Supplier: Aero Design

Color: Black

WO#: 2014-42

PO# N/A





Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity: 1

PN: 95942-02

Aircraft: Bell

Model: 429

Description: Plate

Supplier: Aero Design

Color: Black

WO#: 2014-42

PO# N/A



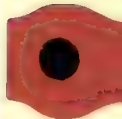
Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity: 1
PN: 95931-10
Aircraft: Bell
Description: Stop Pin
Supplier: Aero Design
Color: Black
WO#: 2014-42

Model: 429

PO# N/A





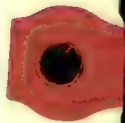
Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity: 1
PN: 95931-11
Aircraft: Bell
Description: Leaver
Supplier: Aero Design
Color: Black
WO#: 2014-42

Model: 429

PO# N/A





Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity: 1

PN: 95942-01

Aircraft: Bell

Model: 429

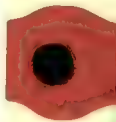
Description: Plate

Supplier: Aero Design

Color: Black

WO#: 2014-42

PO# N/A





Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity: 1

PN: 95942-01

Aircraft: Bell

Model: 429

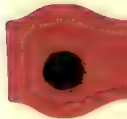
Description: Plate

Supplier: Aero Design

Color: Black

WO#: 2014-42

PO# N/A





Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity: 1

PN: 95942-01

Aircraft: Bell

Model: 429

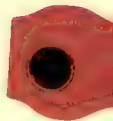
Description: Plate

Supplier: Aero Design

Color: Black

WO#: 2014-42

PO# N/A





Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity: 1

PN: 95942-02

Aircraft: Bell

Model: 429

Description: Plate

Supplier: Aero Design

Color: Black

WO#: 2014-42

PO# N/A





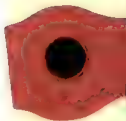
Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity: 1
PN: 95942-02
Aircraft: Bell
Description: Plate
Supplier: Aero Design
Color: Black
WO#: 2014-42

Model: 429

PO# N/A





Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity: 1
PN: 95942-02
Aircraft: Bell
Description: Plate
Supplier: Aero Design
Color: Black
WO#: 2014-42

Model: 429

PO# N/A





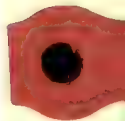
Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity: 1
PN: 95942-01
Aircraft: Bell
Description: Plate
Supplier: Aero Design
Color: Black
WO#: 2014-42

Model: 429

PO# N/A





Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Rim No. of pieces: 1

Manufacturer: Aero Design

Part No.: _____ Serial / Batch No.: _____

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2014-04

Remaining Tasks to be Performed: 425 frame created on
WO # 2014-011

Signature: [Signature]

Date: Jun 21/14 Lic. No. / ACA AD01

In Process



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity: 1
PN: 36280-01
Aircraft: All
Description: Lid Prop
Supplier: Aero Design
Color:
WO#: 2014-28

Model: All

PO#



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity: 1

PN: 95931-11

Aircraft: Bell

Model: 429

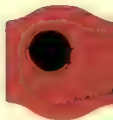
Description: Leaver

Supplier: Aero Design

Color: Black

WO#: 2014-42

PO# N/A





Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity:

1

PN:

95931-11

Aircraft:

Bell

Model: 429

Description:

Leaver

Supplier:

Aero Design

Color:

Black

WO#:

2014-42

PO# N/A



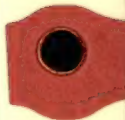
Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity: 1
PN: 95931-10
Aircraft: Bell
Description: Stop Pin
Supplier: Aero Design
Color: Black
WO#: 2014-42

Model: 429

PO# N/A





Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity: 1
PN: 95942-02
Aircraft: Bell
Description: Plate
Supplier: Aero Design
Color: Black
WO#: 2014-42

Model: 429

PO# N/A





Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity: 1
PN: 95942-02
Aircraft: Bell
Description: Plate
Supplier: Aero Design
Color: Black
WO#: 2014-42

Model: 429

PO# N/A

